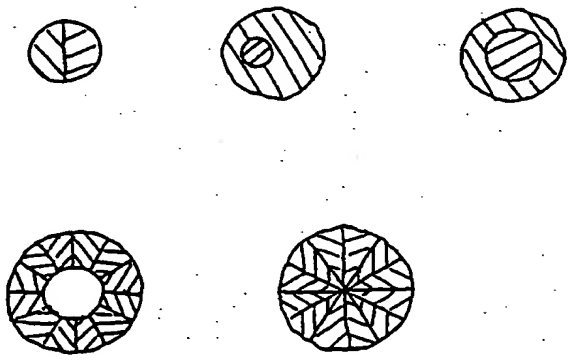




PCT

WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau

INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : A61K 7/16	A2	(11) International Publication Number: WO 96/39117 (43) International Publication Date: 12 December 1996 (12.12.96)
<p>(21) International Application Number: PCT/US96/09084</p> <p>(22) International Filing Date: 5 June 1996 (05.06.96)</p> <p>(30) Priority Data: 08/467,814 6 June 1995 (06.06.95) US</p> <p>(60) Parent Application or Grant (63) Related by Continuation US 08/467,814 (CON) Filed on 6 June 1995 (06.06.95)</p> <p>(71) Applicant (for all designated States except US): GILLETTE CANADA INC. [CA/CA]; 16700 Trans Canada, Kirkland, Quebec H9H 4Y8 (CA).</p> <p>(72) Inventors; and (75) Inventors/Applicants (for US only): TSENG, Mingchih, M. [US/US]; 4 Partridge Drive, Hingham, MA 02043 (US). MASTERMAN, Thomas, Craig [US/US]; 35 Myrtle Street No. 3; Boston, MA 02114 (US). PARK, Edward, Hosung [US/US]; 28 Turning Mill Lane, Sharon, MA 02067 (US). ROBERTS, Michael, F. [IE/US]; 1047 Southern Artery No. 502, Quincy, MA 02169 (US). SPENCER, Jean, L. [US/US]; 19 Middle Street No. 4, Boston, MA 02127 (US).</p>	<p>(74) Agents: GALLOWAY, Peter, D.; Ladas & Parry, 26 West 61st Street, New York, NY 10023 (US) et al.</p> <p>(81) Designated States: AL, AM, AT, AU, AZ, BB, BG, BR, BY, CA, CH, CN, CZ, DE, DK, EE, ES, FI, GB, GE, HU, IL, IS, JP, KE, KG, KP, KR, KZ, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TR, TT, UA, UG, US, UZ, VN, ARIPO patent (KE, LS, MW, SD, SZ, UG), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).</p> <p>Published Without international search report and to be republished upon receipt of that report.</p>	
<p>(54) Title: DENTAL FLOSS</p> <p>(57) Abstract</p> <p>Improved dental flosses are provided, including multicomponent coextruded filaments and/or filaments having a multilobal cross section. Some preferred flosses of the invention are capable of bulking.</p> <div style="text-align: right;">(144 such filaments)</div> 		

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AM	Armenia	GB	United Kingdom	MW	Malawi
AT	Austria	GE	Georgia	MX	Mexico
AU	Australia	GN	Guinea	NE	Niger
BB	Barbados	GR	Greece	NL	Netherlands
BE	Belgium	HU	Hungary	NO	Norway
BF	Burkina Faso	IE	Ireland	NZ	New Zealand
BG	Bulgaria	IT	Italy	PL	Poland
BJ	Benin	JP	Japan	PT	Portugal
BR	Brazil	KE	Kenya	RO	Romania
BY	Belarus	KG	Kyrgyzstan	RU	Russian Federation
CA	Canada	KP	Democratic People's Republic of Korea	SD	Sudan
CF	Central African Republic	KR	Republic of Korea	SE	Sweden
CG	Congo	KZ	Kazakhstan	SG	Singapore
CH	Switzerland	LI	Liechtenstein	SI	Slovenia
CI	Côte d'Ivoire	LK	Sri Lanka	SK	Slovakia
CM	Cameroon	LR	Liberia	SN	Senegal
CN	China	LT	Lithuania	SZ	Swaziland
CS	Czechoslovakia	LU	Luxembourg	TD	Chad
CZ	Czech Republic	LV	Latvia	TG	Togo
DE	Germany	MC	Monaco	TJ	Tajikistan
DK	Denmark	MD	Republic of Moldova	TT	Trinidad and Tobago
EE	Estonia	MG	Madagascar	UA	Ukraine
ES	Spain	ML	Mali	UG	Uganda
FI	Finland	MN	Mongolia	US	United States of America
FR	France	MR	Mauritania	UZ	Uzbekistan
GA	Gabon			VN	Viet Nam

DENTAL FLOSS

Tooth decay and dental disease can be caused by bacterial action resulting from the formation of plaque about the teeth and/or the entrapment of food particles in interstices between the teeth. Removal of plaque and entrapped food particles reduces the incidence of caries, gingivitis, and mouth odors as well as generally improving oral hygiene. Conventional brushing has been found to be inadequate for removing all entrapped food particles and plaque. To supplement brushing, dental flosses and tapes have been recommended.

Dental flosses including a thickened "brush" portion have been developed. These flosses may also include a thin "floss" portion and a threader. The brush portion, when drawn between tooth surfaces, provides good cleaning action which removes materials left by a standard thin floss used alone.

To form a brush floss, it is necessary to provide bulked filaments in a strand of floss, i.e., filaments which are separated and have a somewhat sinuous, random orientation.

Dental flosses, both in brush and thin floss form, often include additives such as flavors or colors. These flavors have been conventionally applied by coating the additive onto the surface of the floss.

The present invention features improved dental flosses and filaments for use in manufacturing dental flosses. preferably, the filaments are

- 2 -

multicomponent coextruded filaments. By "multicomponent", we mean that the filaments have two or more components; by "coextruded", we mean that at least two of the components are present in the form of substantially separate phases having a distinct interface between them, rather than being intermixed. The filaments are preferably formed by processes which are referred to in the art as "coextrusion", but the term "multicomponent coextruded", as used herein, encompasses filaments having the structure described above which are manufactured by other processes.

In one aspect of the invention, the improved flosses of the invention include filaments that are capable of being "bulked" to form a brush floss.

The filaments may include polymers that have been partially or fully oriented, i.e., the molecules of the polymer have been extended from their normal position, during manufacture. Orientation is preferably obtained by pretensioning the filaments during the manufacturing process. When tension is released, e.g., by unwinding the floss from a spool, the filaments relax, causing the floss to bulk. These flosses are referred to herein as "self-bulking flosses", as they will bulk when tension is released without any other bulking step.

Alternatively, the filament may include polymers that are not oriented (or not oriented to any appreciable degree) during manufacture. Flosses containing these filaments, although they can be bulked using conventional methods, e.g., steam or hot air bulking, if desired, are preferably bulked simply by applying tension to the floss, causing orientation of the polymers, and then releasing the tension. These flosses can be bulked by a user of the floss immediately prior to use, or even while the floss is between the user's teeth, if desired. These flosses are referred to herein as "tension-induced bulking

flosses".

Advantageously, both the "self bulking" and "tension-induced bulking" flosses can be bulked simply by applying tension to the floss. Bulking is believed
5 to result from a combination of the differences in the relaxation rates of the various components of each multicomponent filament, the degree of adhesion at the interface between the components, and the geometry of the relative cross-sections of the components of each
10 filament. Thus, these flosses can be easily manufactured without cumbersome additional manufacturing steps (e.g., polymer coating, selective solvent removal, steam or hot air treatment).

In preferred embodiments, the floss is
15 twisted and coated either before bulking (in the case of tension induced bulking floss) or after bulking (in the case of self bulking floss). Some preferred flosses include both bused and non-bulked portions, achieved by applying tension selectively to
20 predetermined portions of the floss. Other preferred flosses include one or more additives incorporated into one or more of the components, e.g., a color which appears, or a flavor, scent or active ingredient which is released, upon bulking.

According to another aspect of the invention,
25 improved dental flosses are formed of filaments that include two or more components selected to provide desired properties to the floss. For example, the filaments may include an inner core selected to provide
30 strength to the floss, and an outer layer selected to provide a desired surface property, e.g., slipperiness, softness, or abrasiveness. Flosses according to this embodiment of the invention may or may not be capable of bulking, depending upon the combination of
35 components selected.

A further aspect of the invention features improved dental flosses that include filaments in which

- 4 -

one or more of the filament components includes an additive, e.g., a color, fragrance, flavor or active ingredient, which is releasable from the floss. Some preferred flosses are capable of bulking. Some

5 preferred flosses include a combination of components selected to give the floss desired properties other than bulking, e.g., surface properties such as slipperiness combined with good tensile strength. The additive-containing component(s) may be water-soluble,

10 to allow the additive to leach from the floss during use, or the floss may release the additive upon bulking. The additive may be provided as supplied, in microencapsulated form, or adsorbed or absorbed onto another additive, e.g., a particulate filler. The

15 additive can also be provided on charged microspheres, as described in U.S. Patent No. 5,300,290, the disclosure of which is incorporated herein by reference.

Advantageously, additives can be incorporated

20 into the flosses of the invention during manufacture of the filaments, rather than applying the additives later during separate coating steps. This not only reduces the number of processing steps, but also reduces the amount of additive needed.

In yet another aspect, the invention features

25 improved flosses that include filaments which have a multilobal cross-section. These flosses may include single component or multicomponent filaments, and, in the latter case, may or may not be capable of bulking.

30 The multilobal cross-section may improve the comfort and cleaning properties of the floss.

The invention further features methods of making the improved flosses. A preferred method includes (a) coextruding two or more polymers through a

35 multicomponent die to form a plurality of multicomponent filaments; and (b) treating the filaments to form a fiber adapted for use as a dental

floss.

Additionally, the invention features methods of flossing the teeth of a mammal, e.g., a human, by inserting between two teeth of the mammal a length of a dental floss of the invention.

The term "dental floss", as used herein, is defined to include dental flosses, dental tapes, and similar articles.

Other features and advantages of the invention will be apparent from the drawings, the following detailed description, and the claims.

Fig. 1 is a schematic, highly enlarged, side view of a length of dental floss prior to bulking. Fig. 1a is a schematic, highly enlarged, side view of the dental floss of Fig. 1 after bulking.

Fig. 2 is a schematic view of a production line for manufacturing a self-bulking brush dental floss according to one embodiment of the invention.

Figs. 3 - 3d are cross-sectional views, taken radially, of multicomponent coextruded filaments having various cross-sections.

Fig. 4 is a cross-sectional view, taken radially, of a trilobal single component filament according to one embodiment of the invention. Fig. 4a is a cross-sectional view, taken radially, of a trilobal multicomponent filament having a sheath/core cross-section; Fig. 4b is a cross-sectional view, taken radially, of a trilobal multicomponent filament having a tipped cross-section.

Fig. 5 is an electronmicrograph of a filament containing kaolin particles in its sheath component.

Bulking Flosses

Referring to Figs. 1 and 1a, a length of dental floss is shown before and after bulking. Prior to bulking, the filaments which comprise the floss are arranged close together to form a fiber and are substantially parallel to each other in the axial

direction (Fig. 1)

After bulking, as shown in Fig. 1a, the dental floss is in the form of a brush, i.e., the filaments are relatively widely spaced and are no longer substantially axially parallel, but instead are somewhat sinuous and randomly oriented. Preferably, the brush floss has, in its relaxed state, a diameter that is at least 300 to 550 percent of the original diameter of the fiber prior to bulking, and a denier of from about 500 to 700. Preferred brush flosses have sufficient strength to resist fraying and breaking during use, typically a breaking strength of at least 5 N, preferably at least 10 N, more preferably about 25 N.

Under tension, during use, the brush stretches to become a thread, suitable for easy insertion between the teeth and for upward and downward scraping motion along the opposed tooth surfaces. When not under tension, the brush is yarn-like, suitable for cleaning between the teeth in a brushing action, pulling the brush floss back and forward across tooth and gingival surfaces.

The floss is formed of a fiber comprising a plurality of multicomponent filaments formed of two or more polymeric components. The components are selected to exhibit differing rates of relaxation as a result of their viscoelasticities and/or crystalline structure, and/or to have relative cross-sections, and/or to have a degree of adhesion at their interface, which will result in bulking upon orientation and subsequent relaxation of the filaments.

A difference in relaxation rate can be achieved by utilizing distinct polymers, e.g., nylon and polyester, or different grades of the same polymer, i.e., grades having different Melt Flow Indices (MFIs), relative viscosities (RVs) or molecular weights. The polymers preferably have different viscoelasticities,

and/or different crystalline structure, e.g., a different ratio of crystalline to amorphous material. It is noted that even if one or more of the components (although not all of the components of the filament) is stretched to a point exceeding the elastic limit of the component, such that for all practical purposes relaxation of these components does not occur, the filament will still generally be capable of bulking.

A difference in cross-section can be achieved by, e.g., arranging the components so that their cross-sections are asymmetric, or so that they occupy unequal percentages of the volume of the filament. Suitable cross-sections for the filaments include side-by-side (Fig. 3), sheath/core eccentric (Fig. 3a), sheath/core (Fig. 3b), hollow pie (Fig. 3c) and pie (Fig. 3d).

A degree of adhesion which will result in bulking can be readily determined empirically. Generally, materials having lesser adhesion to each other will have a greater tendency to cause bulking when combined in a filament. If desired, agents can be added to modify the adhesion of the materials, decreasing the adhesion of compatible components or increasing the adhesion of otherwise incompatible components. These agents are well known in the plastics art.

Suitable material combinations include but are not limited to nylon and polyester; high MFI polypropylene (e.g., having an MFI of from 20 to 50) and low MFI polypropylene (e.g., 5 to 20); high RV nylon (e.g., having an RV of from 3 to 5) and low RV nylon (e.g., 1 to 3); polyester and polypropylene; and nylon and polypropylene. Preferably, the two components are provided in a volumetric ratio of from about 5:95 to 95:5.

Methods of forming preferred self-bulking and tension-induced bulking brush flosses will now be described.

Self-Bulking Floss

A method for forming a preferred self-bulking dental floss is shown schematically in Fig. 2. First, two or more polymers are coextruded through a two component extrusion die to form a bicomponent filament, the physical properties and/or the relative cross-sections of the polymers being selected, as described above, to enable the floss to be bulked.

Preferably, the extrusion die includes a spinneret, as is known in the filament forming art, through which a plurality of these bicomponent filaments are extruded at once. Preferred flosses contain from 72 to 288 filaments and have a total denier of from about 500-3000. The filaments exiting the spinneret are gathered to form a fiber, which then passes through a cooling chamber, preferably at 0 to 30°C., and is placed under light tension as it travels between two drawing godets which are rotating at different speeds. The tension applied to the fiber is expressed as the "drawdown ratio", which is the speed differential between the two drawing godets. Preferred drawdown ratios are from about 1.0 to 5.0, more preferably about 1.5 to 4.0. The fiber then passes through a relaxing godet and is collected on a take-up winder. As soon as tension is removed from the fiber, the filaments of the fiber separate or "bulk", forming a brush.

The bulked fiber can then be further treated to form a finished brush floss. For example, preferred flosses are twisted, preferably about 1 to 1.5 twists per inch, and coated with a bonding solution. Twisting and coating reduces excessive filament separation and improves fray resistance. Twisting processes are well known, e.g., using standard ring twisting equipment. Coating may be accomplished in any suitable manner, e.g., by dip coating, i.e., imbibing the filament in a bath of the coating, removing the excess coating as the

- 9 -

filament exits the bath, and drying the filament to remove solvent in an air stream. The drying rate may be accelerated by heating the air stream, e.g., to 60°C. Suitable coating solutions include a coating of 80/20
5 GENTAL 101 nylon polymer (General Plastics, Bloomfield, NJ) in ethanol, SPENLITE L89 or SPENKEL M21 polyurethane coating (Reichold Chemicals, Research Triangle Park, NC). The coating should be flexible enough not to inhibit bulking but heavy enough to bond
10 the filaments adequately to prevent excessive fraying.

Tension Induced Bulking Floss

Tension induced bulking flosses are manufactured in a manner similar to that described above, except that tension is not applied to the fiber
15 at any time (other than incidental minor amounts of tension resulting from movement of the fiber through the processing equipment). Thus, the drawdown ratio is approximately 1.0, if equipment including the drawing godets is used (these godets are not necessary if no
20 tension is to be applied, but can be left in place if it is desired to use the same production line to manufacture both self-bulking and tension-induced bulking flosses).

Ideally, for tension induced bulking flosses
25 the fiber has, prior to bulking, a denier of approximately 1750-2800, so that when it is pulled to its natural draw limit range of about 3 to 4 it has a final denier of 500-700.

Specialty Bicomponent Filaments

30 In another embodiment of the invention, the filaments used to form the dental floss include two or more components, each of which contributes a desired property to the filament. These filaments may or may not impart bulking capability to the floss, depending
35 upon the factors discussed above (relative relaxation rates, adhesion, cross-sectional geometry).

These filaments may be manufactured using the

- 10 -

same process described above, preferably with tension applied during manufacture, as described above for the self-bulking flosses. (Depending upon the components selected and cross-sectional geometry, the applied
5 tension may or may not cause bulking; however, it is generally preferred to apply tension in any case, as this has been found to improve the tensile strength of the filaments.)

Some preferred filaments include an outer
10 sheath which is soft, slippery, or abrasive, to improve the ease of insertion, comfort and cleaning capability, respectively, of the floss, and an inner core that provides other desired physical properties such as strength and resiliency and/or serves as a carrier for
15 additives, such as flavors, scents and medicaments.

Where the outer layer is intended to provide softness, for ease of insertion, preferred polymers include TPEs (thermoplastic elastomers), e.g., polyether block amides such as those available under
20 the tradename PEBAX from ELF Atochem, polyester elastomers such as those available under the tradename HYTREL from DUPONT, and styrene butadiene block copolymers such as those available under the tradename KRATON from Shell; EVA (ethylene vinyl acetate);
25 ethylene-propylene copolymers; low MFI polypropylene, and mixtures thereof.

Where the outer layer is intended to provide slipperiness, for comfort during use; preferred polymers include polyethylene, melt extrudable
30 fluoropolymers (e.g. polyvinylidene fluoride (PVDF), and fluorinated ethylene propylene copolymers), polymers containing polytetrafluoroethylene (PTFE) particles and/or silicone oil, melt extrudable lubricating polymers (e.g., polyoxyethylene such as is
35 commercially available from Union Carbide under the tradename Polyox®, or triblock copolymers of polyethylene oxide and polypropylene oxide such as

- 11 -

those available from BASF under the tradename Pluronic®), and melt extrudable lubricous polymer alloys (e.g., Lubriloy® polymers available from LNP engineering plastics).

5 If the outer layer is to include an abrasive, for improved cleaning, preferred abrasive/polymer combinations include nylon containing particles of kaolin, calcium carbonate, zinc oxide, silica, PTFE, or blends of these particles which are compatible. If
10 desired, one or more additives may be absorbed or adsorbed on the surface of the abrasive particles, e.g., by drum drying, spray drying, fluidized bed processing, or other suitable methods as is known in the art.

15 In all of the above cases, one of the polymers is preferably a reinforcing polymer, e.g., nylon, polyester or polypropylene, to impart tensile strength and/or rigidity to the floss.

 In one embodiment, one of the polymers may be
20 selected to have a suitable melt temperature and other properties to enable the filaments to bond to each other to form the finished floss without the coating and twisting procedure described above. A suitable multicomponent fiber for use in this embodiment is
25 described in Example 4, sample 1. The filaments are bonded by softening and flattening the fiber on a heated draw roll as it is being passed by the godets.

 The sheath and core may have any suitable cross-section, preferably a symmetric sheath/core
30 cross-section (Fig. 3b) or an eccentric sheath/core cross-section (Fig. 3a). The filament may also have a hollow pie cross-section (Fig. 3c), and, if desired, the hollow core may be filled with an additive, e.g., a flavor, color or active ingredient.

35 Specialty bicomponent flosses can also be formulated to include one or more additives, e.g., a color, fragrance, or active ingredient, in one or both

- 12 -

of the components.

For example, the outer layer may be polyester, nylon or other thermoplastic, and the inner core may be a different thermoplastic (or different
5 grade of the same thermoplastic) which contains an additive such as chlorhexidine (or a salt thereof), sodium fluoride, flavor (e.g., Polyiff®, International Flavors and Fragrances), fragrance, tooth desensitizer, tooth whitener or other additives suitable for use in
10 dental flosses. The thermoplastic to be used for the inner core will be determined by the additive used, as would be readily appreciated by one skilled in the art. Suitable polymers include nylon, polyester, polypropylene, ethylene vinyl acetate (EVA), polyvinyl
15 alcohol, polyethylene and alike. The inner or outer polymer may be water soluble to allow the additive to leach out of the polymer.

Alternatively, the polymers may be selected to render the floss capable of bulking, and the
20 additive can be released upon bulking. Release upon bulking can occur due to various mechanisms, or combinations of mechanisms. For example, the additive can be provided in encapsulated form, and the shearing action of bulking can rupture the capsules, or the
25 portion of the additive present at the interface of the components can be exposed by separation of the components at the interface during bulking. A preferred material for the additive-containing component in this embodiment is polypropylene, as its
30 low extrusion temperature minimizes degradation of temperature-sensitive additives. The additive may be a color which is incorporated in a manner so that the color is only visible either before or after bulking, i.e., so that the floss changes color to indicate
35 bulking. This can occur by various mechanisms, e.g., by the color being diluted by the expansion of the fiber during bulking, so that the floss changes from a

- 13 -

color to white, by selecting the cross-section so that bulking exposes a component of a different color, or by one of the components being a polymer, such as ABS, which changes color when tension is applied to it.

5 The additive, if desired, can be incorporated in encapsulated form. Encapsulation may be used for thermal protection or moisture protection of the additive, and may be accomplished by any number of conventional techniques such as spray drying, drum
10 drying or solvent evaporation. The additive can also be provided on a charged microsphere, as described in U.S. Patent No. 5,300,290.

Suitable cross-sections include sheath/core, sheath/core eccentric, side-by-side, pie and hollow pie
15 (see Figs. 3-3d).

Multilobal Filaments

Other preferred flosses include a plurality of filaments having a multilobal cross-section, as shown in Fig. 4. Preferred filaments include from 3 to
20 8 lobes; one suitable filament has 3 lobes. The filaments are preferably formed by extrusion through a die having the appropriate multilobal cross-section.

These filaments may be multicomponent or single component, and, if the former, may have a
25 sheath/core (Fig. 4a), tipped (Fig. 4b), or other suitable cross-section. Suitable polymers for use in forming multilobal filaments include but are not limited to polyester, polypropylene and nylon. In multicomponent filaments, if desired the polymers may
30 be selected, as described above, to render the floss capable of bulking.

Suitable methods of forming flosses using these multilobal filaments include any conventional floss manufacturing methods. The twisting and coating
35 methods described above are preferred.

The following examples are intended to be illustrative and not of limiting effect.

- 14 -

ExamplesEquipment Set-Up

The following equipment set-up and manufacturing procedure, shown schematically in Fig. 2, was used in all examples.

Two 1.5 inch diameter extruders were connected to a two component extrusion die. The two extruders included 30/1 L/D ratio general purpose screws. The two component extrusion included a metering plate, a distributing plate, etched plates, and a spinneret. After being coextruded through the extrusion die, the extrudate was processed with a downstream filament spinning set-up to produce filaments. The downstream set-up included a cooling chamber, finish applicator, tensioner, drawing godets, relaxing godet, and winder. The extrudate was cooled at the cooling chamber, stretched and relaxed by drawing and relaxing godets, and collected on the take-up winder.

Example 1Manufacturing Dental Floss from FilamentsSelf-Bulking Floss

A fiber containing 144 bicomponent filaments of 70/30 nylon 6/PET (side-by-side cross-section) drawn using a drawdown ratio of 3.28, using the equipment and procedure described above, was converted to floss in the following manner.

The fiber was first twisted to reduce filament separation during flossing and to add fray resistance. Twisting was carried out using standard ring twisting equipment, at a twist level of 1.5 twists per inch. Once twisted, the filament was dip coated in a coating of 80/20 GENTAL 101 nylon polymer in ethanol. Removal of the solvent after dip coating was accelerated by heating the air stream to 60°C.

Tension-Bulked Floss

A fiber containing 144 bicomponent filaments,

- 15 -

side-by-side cross-section, drawdown ratio of 1.0, 80/20 nylon 6/PET was used. A blue dye was incorporated into the nylon resin, and the PET was white (pigmented with TiO_2).

5 To convert the fiber to a floss, the fiber was twisted to between 1 and 1.5 twists per inch, and subsequently dip-coated with a bonding solution and allowed to dry at 65°C to its final form. The bonding solution used was SPENLITE L89 polyurethane coating.

10 Example 2

 Using the equipment set-up and procedure described above to form the initial fiber, and a procedure similar to that described in Example 1 to form the final floss, the following self-bulking
15 flosses were formed:

Sample No.:	1	2	3	4
Components	Nylon 6 (2.7 RV) Polyester (0.64 MFI)	Nylon 6 (4.0 RV) Polyester (0.64 MFI)	Nylon 6 (2.7 RV) Polyester (0.64 MFI)	Polyester 0.64 MFI Polypro. 12 MFI
Ratio	70/30	70/30	50/50	50/50
Cross-section	side-by-side	side-by-side	hollow pie	hollow pie
Drawdown Ratio	3.28	3.5	2.2	2.2
# of filaments	144	144	144	144
Total Denier	533	863	1178	982
Color	blue (in nylon)	beige (in nylon)	blue (in nylon)	none added
Tensile strength (g/denier)	3.8	3.3	1.9	1.5
Break strength (kg.)	2.04	2.85	2.25	1.49
Comments	bulked well; changed color	bulked very well; changed color	did not bulk as well	bulked very well

Example 3

Using the equipment set-up and procedure described above to form the initial fiber, and a procedure similar to that described in Example 1 to form the final floss, the following tension-induced bulking flosses were formed:

	Sample No.:	1	2	3	4
	Components	Nylon 6 (2.7 RV) Polyester (0.64 MFI)	Polyester (0.64 MFI) Polypro. (12 MFI)	Nylon 6 (2.7 RV) Polypro. (12 MFI)	Nylon 6 4.0 RV Polyester 0.64 MFI
10	Ratio	70/30	50/50	50/50	70/30
	Cross-section	side-by-side	hollow pie 16 segmts	hollow pie 16 segmts	side-by-side
	Drawdown Ratio	1	1	1	1
15	# of filaments	144	144	144	144
	Total Denier	2758	2205	1966	2355
20	Color/ flavor	blue (in nylon)	green & mint (in polypro)	green & mint (in polypro)	blue (in nylon)
	Tensile strength (g/denier)	1.2	0.7	1.1	0.8
25	Break strength (kg.)	3.32	1.54	2.24	1.82
	Comments	bulked well; changed color	bulked well; changed color; released flavor upon bulking	bulked well; changed color; released flavor upon bulking	bulked well; changed color

- 18 -

Example 4

Using the same equipment set-up and procedures described above, the following specialty bicomponent flosses were formed:

5	Sample No.:	1	2
	Components	TPE (PEBAX 2533) Nylon (4.0 RV)	TPE (HYTREL 3078) Nylon (4.0 RV)
	Ratio	30/70	30/70
	Cross-section	Sheath/core	Sheath/core
10	Drawdown Ratio	3.5	3.4
	# of filaments	144	144
15	Total Denier	580	732
	Tensile strength (g/denier)	5.0	4.1
20	Break strength (kg.)	2.92	3.02
	Color	none	none
	Comments	Fiber needs no bonding or twisting - can be used directly as floss by passing through heated draw rolls; non-bulking	non-bulking

Example 5

25 Using the same equipment set-up and procedures described above, the following specialty bicomponent floss was formed:

- 19 -

Sample No.:	1
Components	Nylon (4.0 RV) Nylon (4.0 RV)
Ratio	30/70
Cross-section	Sheath/core
Drawdown ratio	3.0
# of filaments	144
Total Denier	622
Tensile strength (g/denier)	3.4
Break strength (kg.)	2.11
Additive	2% kaolin in sheath
Comments	kaolin particles on surface observable in electron micrograph (see Fig. 5)

Other embodiments are within the claims.

For example, while bicomponent filaments have been described above in the detailed description, the filaments could contain any desired number of components, and in this case would be manufactured by extrusion through a suitable multicomponent die using the appropriate number of extruders.

- 20 -

C L A I M S

1. A dental floss comprising a plurality of multicomponent coextruded filaments.
2. The dental floss of claim 1, wherein each
5 said filament consists of two components.
3. The dental floss of claim 1, wherein the longitudinal axes of said filaments are arranged substantially parallel to each other to form a fiber.
4. The dental floss of claim 3, wherein said
10 fiber is twisted.
5. The dental floss of claim 1, wherein each filament comprises a first component having a predetermined viscoelasticity and a second component having a different viscoelasticity.
- 15 6. The dental floss of claim 1, wherein each filament comprises a first component having a predetermined crystalline structure and a second component having a different crystalline structure.
7. The dental floss of claim 1, wherein said
20 components of each said multicomponent filament have different radial cross-sectional geometries.
8. The dental floss of claim 1, wherein at least a portion of said filaments are pretensioned during manufacture and, when tension is released, the
25 filaments relax causing the floss to bulk.
9. The dental floss of claim 1, wherein said multicomponent filaments include two or more components selected to have different relaxation rates.
10. The dental floss of claim 1, wherein said
30 multicomponent filaments are selected to have a degree of interfacial adhesion that allows the filaments to bulk upon application of tension to the filaments.
11. The dental floss of claim 1, wherein said floss is adapted to be bulked by a user of the floss
35 immediately prior to or during use by application of tension to the floss.
12. The dental floss of claim 1, wherein said

- 21 -

filaments include a first component selected to provide strength to the floss, and a second component selected to provide a surface having predetermined physical characteristics.

- 5 13. The dental floss of claim 12, wherein said first component forms an inner core and said second component forms a sheath surrounding said core.
14. The dental floss of claim 12 wherein said first component comprises a polymer selected from the group
10 consisting of nylon, polyester and polypropylene.
15. The dental floss of claim 12, wherein said second component comprises a melt extrudable polymer selected from the group consisting of thermoplastic elastomers, ethylene vinyl acetate, ethylene propylene
15 copolymers, fluoropolymers, lubricating polymers, and lubricious polymer alloys.
16. The dental floss of claim 12, wherein said second component comprises a blend of a melt extrudable polymer and a silicone oil.
- 20 17. The dental floss of claim 12, wherein said second component comprises a blend of a melt extrudable polymer and a particulate filler selected from the group consisting of kaolin, calcium carbonate, silica, and polytetrafluoroethylene.
- 25 18. The dental floss of claim 17, wherein an additive is adsorbed or absorbed onto a surface of said particulate filler.
19. The dental floss of claim 1 or 12, wherein one or more of the components of the multicomponent
30 filaments includes an additive.
20. The dental floss of claim 19, wherein the additive is selected from the group consisting of colors, fragrances, flavors, active ingredients, and agents which modify the interfacial adhesion between
35 the components of the filaments.
21. The dental floss of claim 19, wherein the additive is incorporated in a manner to allow it to be

- 22 -

released from the floss during use.

22. The dental floss of claim 19, wherein the components of the multicomponent filaments are selected to render the dental floss capable of bulking.

5 23. The dental floss of claim 22, wherein the additive is a color and is incorporated in a manner to enable the dental floss to change color upon bulking.

24. The dental floss of claim 19, wherein one or more of the components of the multicomponent filaments
10 are water-soluble, to allow the additive to leach from the floss during use.

25. The dental floss of claim 22, where in the additive is incorporated in a manner to allow it to be released from the floss upon bulking.

15 26. A dental floss comprising a plurality of filaments having a multilobal radial cross-section.

27. The dental floss of claim 26, wherein at least a portion of the filaments individually comprise two or more coextruded components.

20 28. The dental floss of claim 27, wherein said two or more components are selected to render the dental floss capable of bulking.

29. The dental floss of claim 26, wherein said filaments have from 3 to 8 lobes.

25 30. The dental floss of claim 27, wherein said filaments have a sheath/core radial cross-section.

31. The dental floss of claim 27, wherein said filaments have a tipped radial cross-section.

32. A method of making a dental floss containing
30 a plurality of multicomponent coextruded filaments, said method comprising:

(a) coextruding two or more polymers through a multicomponent die to form a plurality of multicomponent filaments; and

35 (b) treating said filaments to form a fiber adapted for use as a dental floss.

33. A method of flossing the teeth of a mammal,

- 23 -

comprising

inserting between two teeth of a mammal a length of dental floss comprising a plurality of multicomponent coextruded filaments.

5 34. The method of claim 33, further comprising the step of bulking said floss prior to insertion.

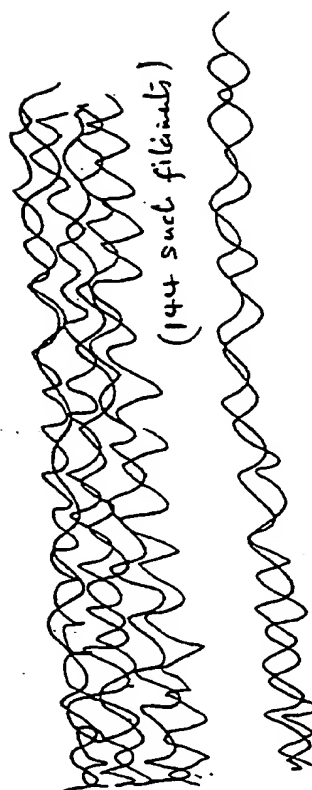
35. The method of claim 33, further comprising the step of bulking said floss while it is between the teeth.

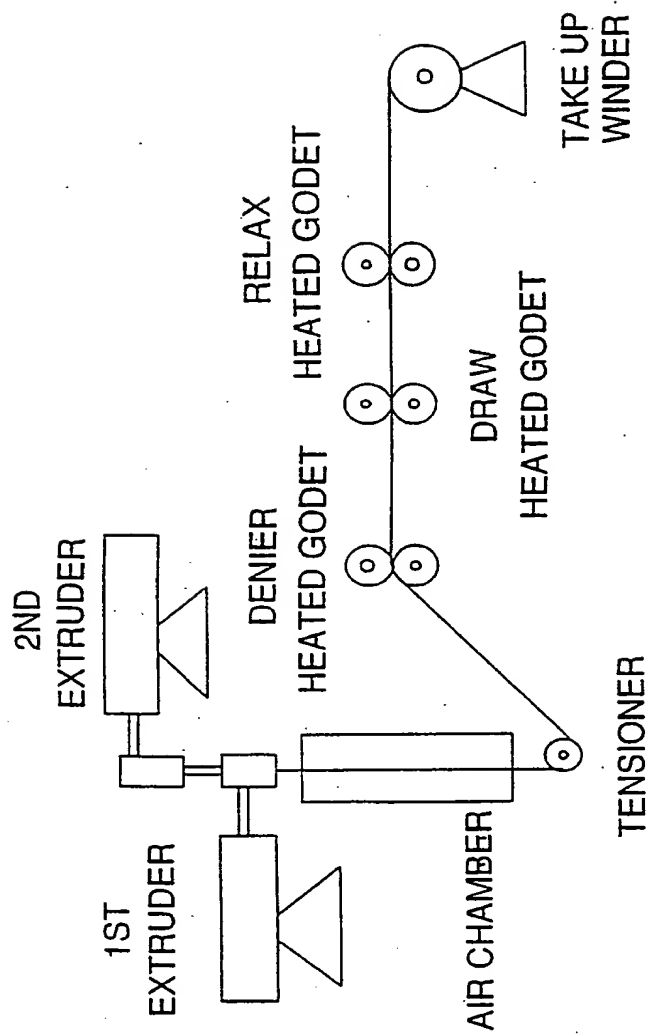
10 36. The method of claim 34 or 35 wherein said bulking step comprises grasping the dental floss at two spaced points and stretching the region of the dental floss between the two points.

FIG. 1



FIG. 1a





FIBER (MULTI FILAMENT) SPINNING PROCESS

Fig. 2

3/4



Fig. 3

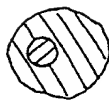


Fig. 3a



Fig. 3b

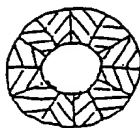


Fig. 3c

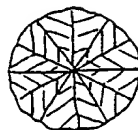


Fig. 3d



Fig. 4

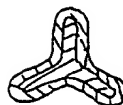


Fig. 4a

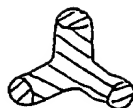


Fig. 4b

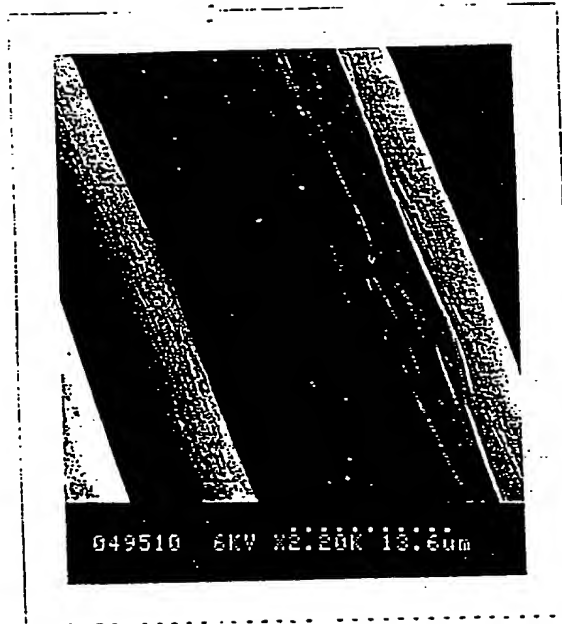


FIG. 5